

**Work Order ID 59733**

Thursday, June 10, 2010 10:00:38 AM



Page 1

Item ID: D4035-045

Accept



Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Fwd (Light)

Stop



Start Date: 6/10/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MDate: 10-6-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R Aluminum rod Batch: 114703 0.00

Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill holes as per dwg D4035 using DT9619
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

SAD 10-07-12(2) 6/10/07.21(P/S)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(2) 10.07.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4035-045 PAR #: \_\_\_\_\_ Fault Category: Large Fob NCR: Yes No DQA: \_\_\_\_\_ Date: 10/07/26  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 10/07/26

NCR: <u>59733</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/7/18	# 100	1 <sup>st</sup> Rib Scrap. holes drilled on side not Bottom as per Dwg. P.C. New Sig. employee didn't know the orientation of the Sig		→ Scrap + Destroy + <del>Rep</del> Replace M 114640 Qty 11	SAD 10-07-12	S 10/07/12		S 10/07/18
				Remove the small dowel pins in the drift sig → Put a note on sig to specify the correct orientation Note included on the sig added	SAD 10-07-12	Co 10/07/12		S 10/07/18

NOTE: Date & initial all entries

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Page 2

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/06/21

(2)

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD

10-07-21

(2)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/21

MF

10-7-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 10, 2010 10:00:43 AM

Page 1

Work Order ID: 59733

Parent Item: D4035-045

Parent Item Name: Lid Rib Assembly, Fwd (Light)

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC


IPP Rev:B as

Start Date: 6/10/2010

Required Date: 6/17/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2953-175 		Manufactured	No			100	Each	19.0000	1	2			
Spacer													

Location

Loc Qty

Loc Code

WA

19

56985

3

57335

16

M6061T6TS0.750W.06  
2

Purchased

No

100

f

186.0965

1.875

3.947368

  
6061-T6 SQ Tube .75 x .75 x .062W

Location

Loc Qty

Loc Code

MAT

108.4213

114573

22.1055

114640

86.3158

MAT06

77.6752

103069

38.0526

104422

15.5263

16441

4.07

9671

20.0263

*Handwritten:* 10.07.21

*Handwritten:* 2

*Handwritten:* SAD 10.07-12

*Handwritten:* 3.9474

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



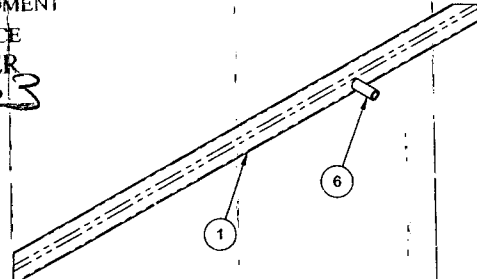
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RETURN TO  
ENGINEERING

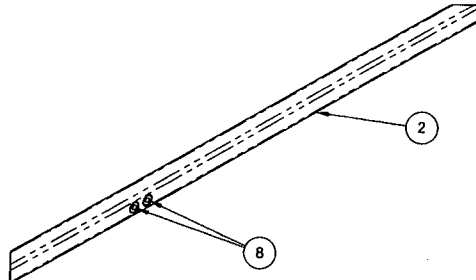
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39733

*PS10-6-10*

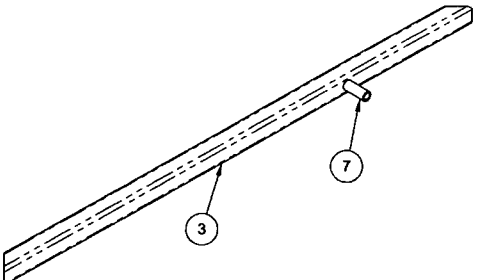
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



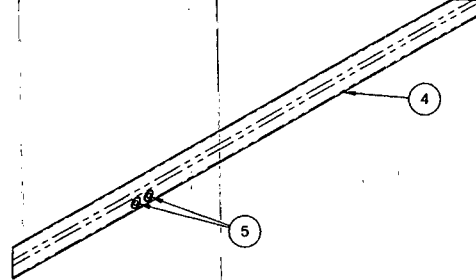
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.04		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4035**

TITLE **BASKET LID RIB ASSY**

REV. A  
SHEET 1 OF 5  
SCALE  
NTS

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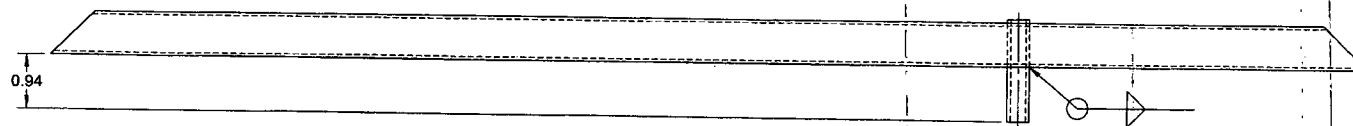
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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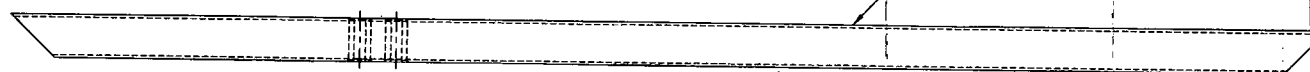
NOTE: Date & initial all entries



D4035-1  
RIB

D2327-3  
SPACER BUSHING

**D4035-041 BASKET LID RIB ASSY, FWD**



D4035-3  
RIB

D4021-9  
BUSHING  
2 PL

TYP

**D4035-043 BASKET LID RIB ASSY, AFT**

W/O 59783

**RELEASED**  
2010-03-12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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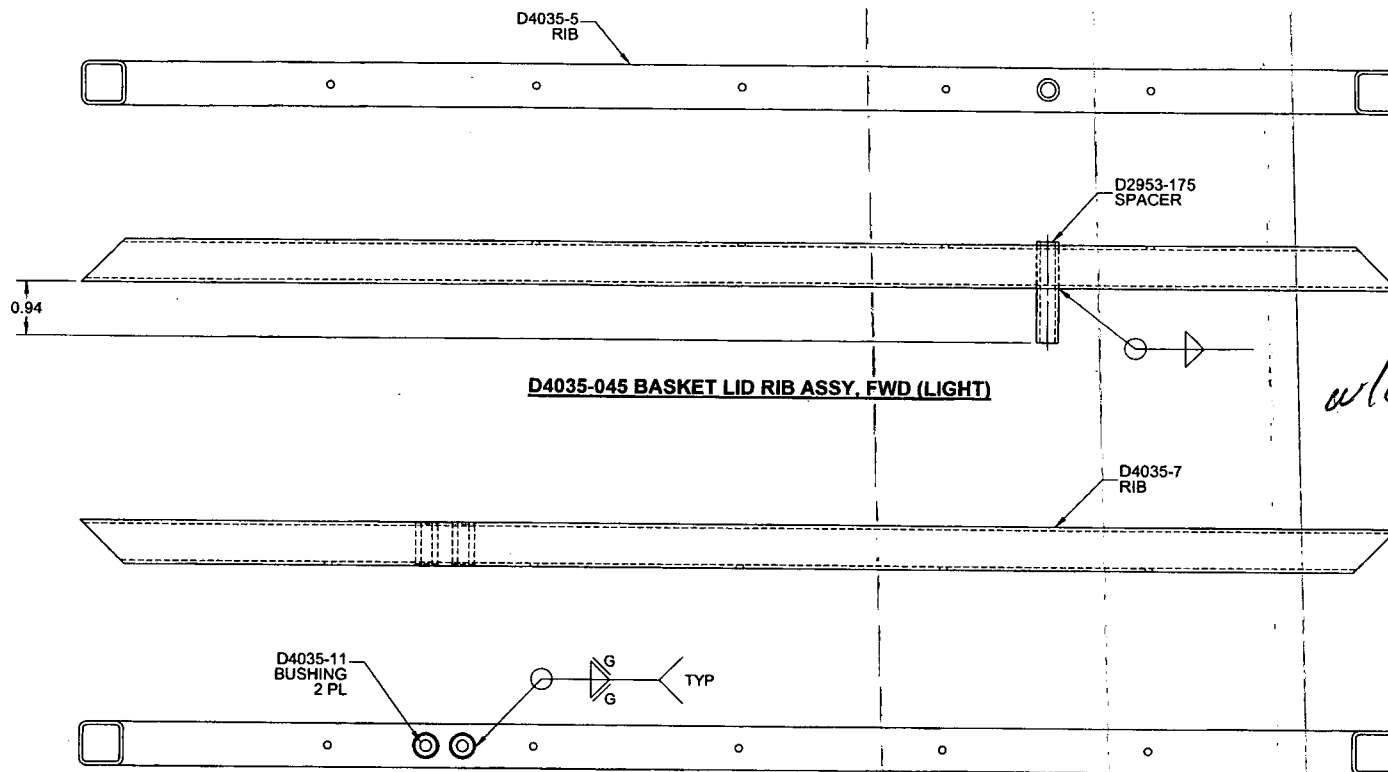
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**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4035</b>	REV. A
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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2010-03-12

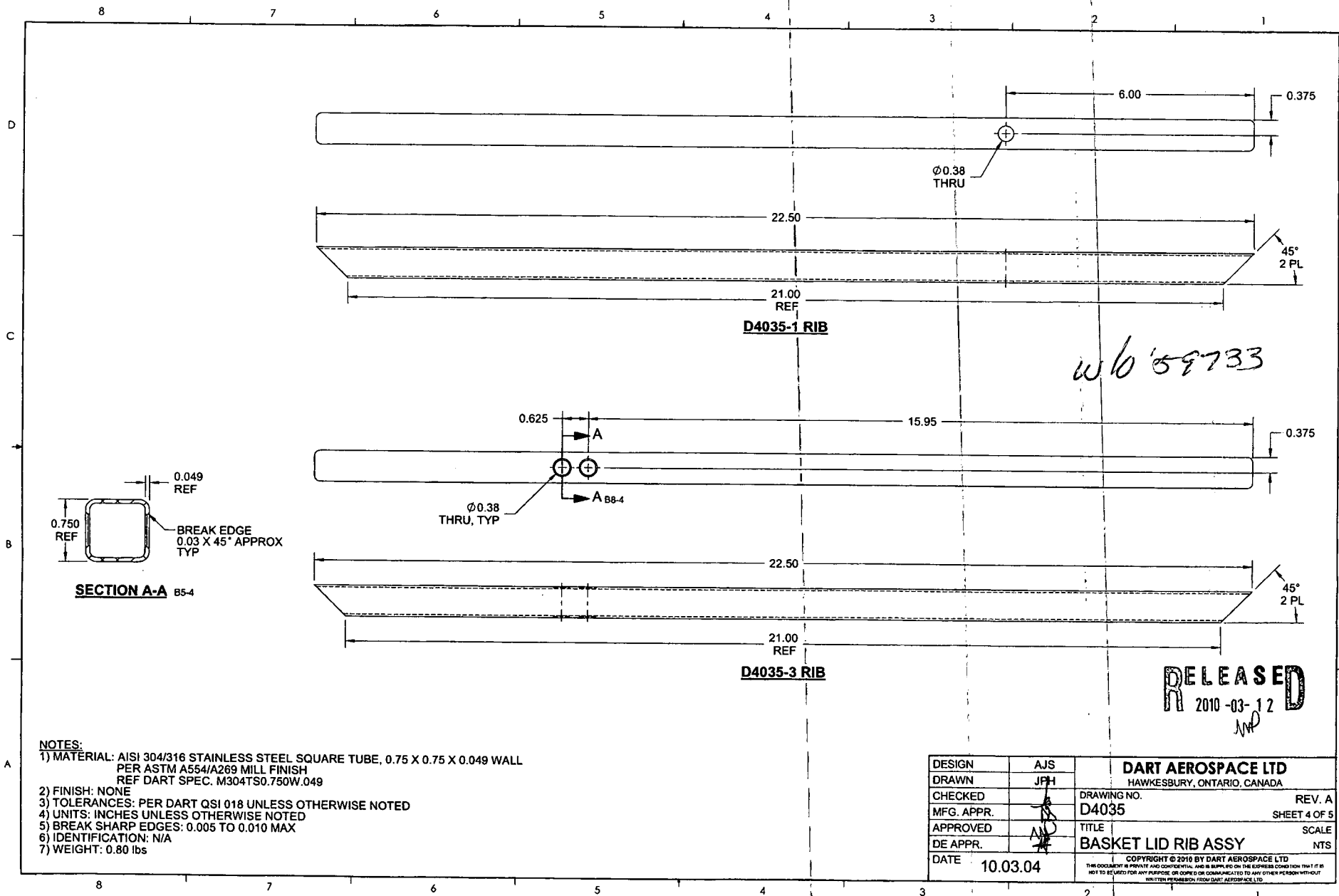
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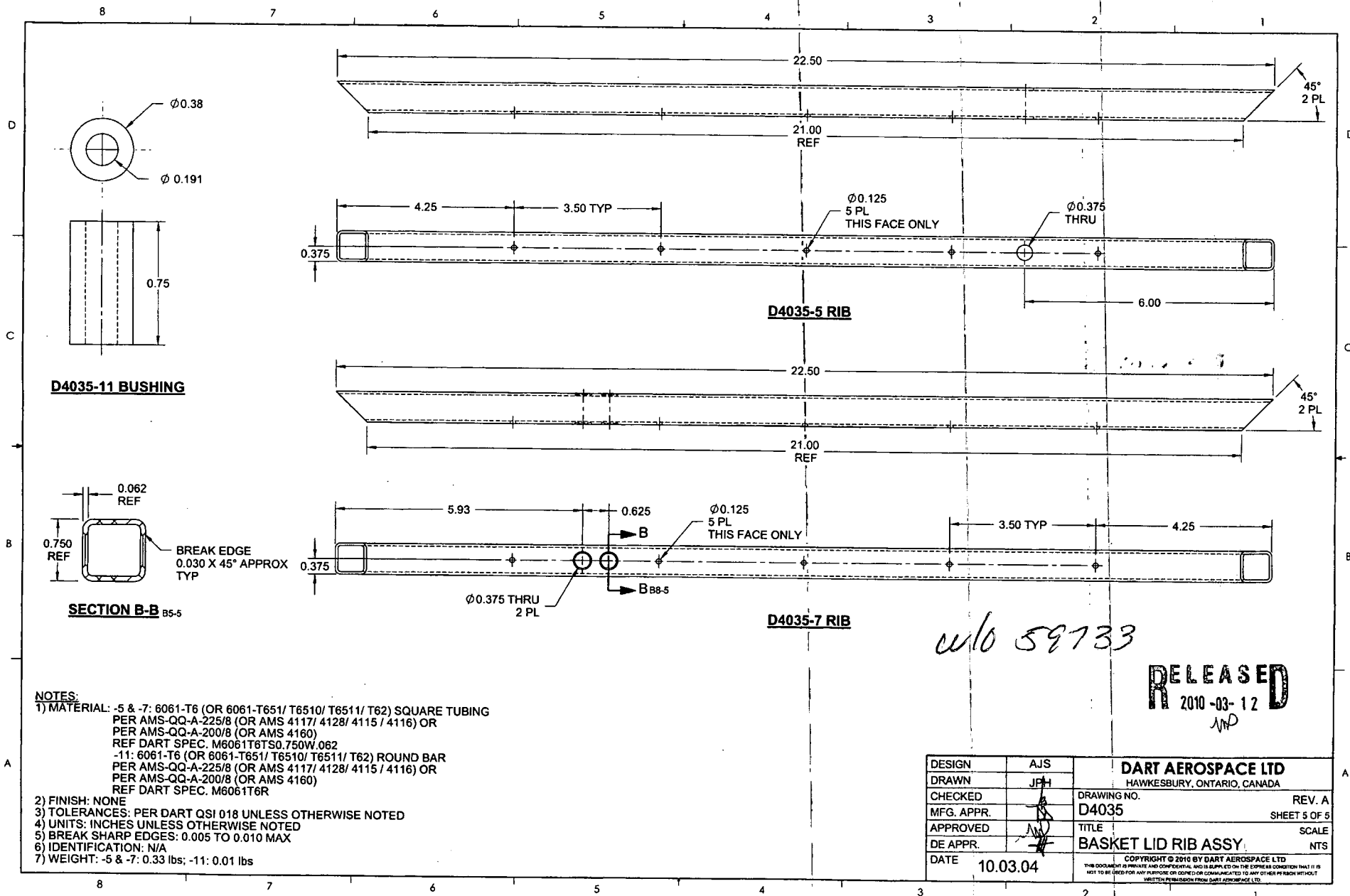
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DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4035</b>	SHEET 5 OF 5
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**RELEASED**  
2010-03-12

W/L 59733



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